

of the pivot about which the sight moves in elevation. These and other exacting requirements make this a very interesting, although difficult, part to produce on an interchangeable basis, and it was necessary to design special radius milling fixtures.

Radial Fixture for Rough-milling Slot. — The slot which is milled in one side of the sight-bar is rough-milled as illustrated



Fig. 17. Fixture for Milling Curved Slot in Sight-bar Bracket

in Fig. 16. This is the type of fixture which has a curved track that causes the work-holding member to follow a circular path as the work feeds past the cutter. The sight-bar *A* is held on a movable part which has a slot *B* in the rear side of the same radius as the slot to be milled. A block *C*, which is free to swivel and is pivoted to a stationary part of the machine, engages slot *B*. The cross-feed

screw in the knee is removed,  
and as the table is fed in a  
lengthwise direction, a slot is  
milled to